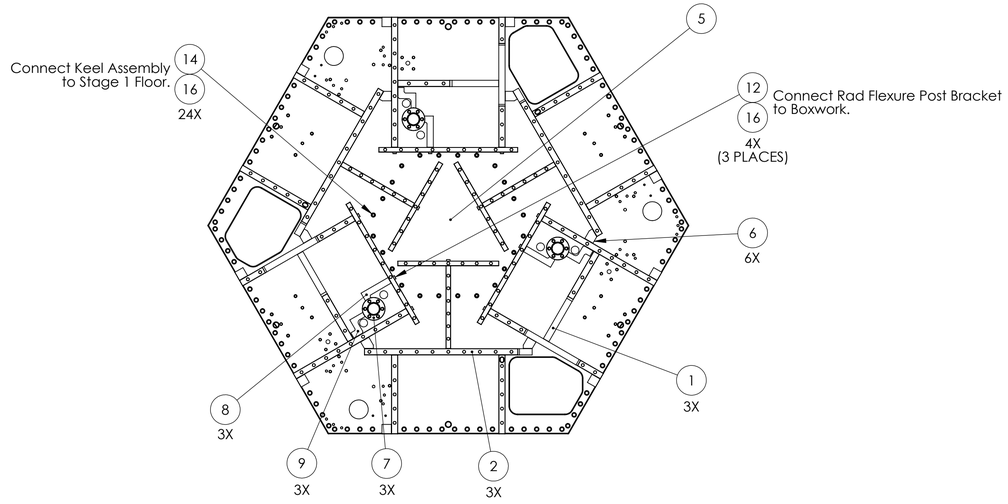
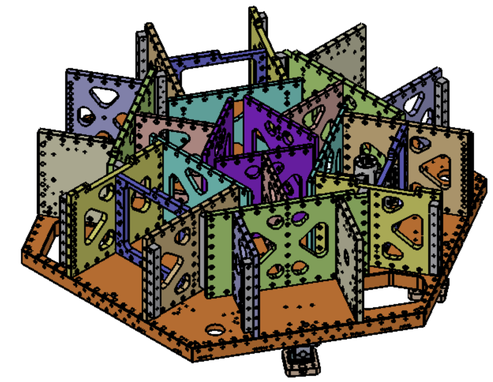
NOTES CONTINUED:

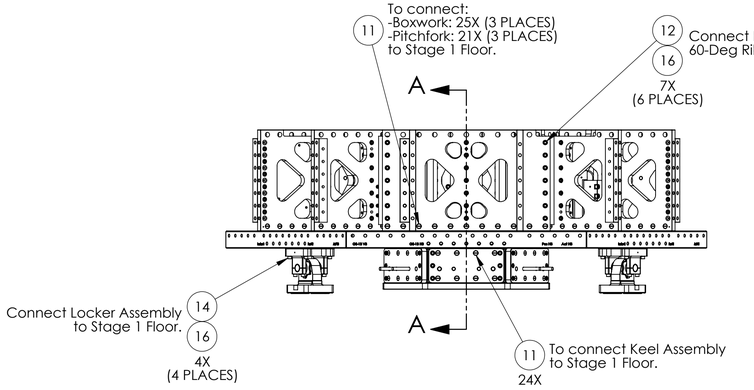
5. Refer to LIGO-E0900216 for assembly instructions.

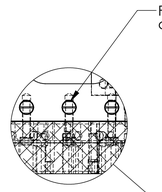
6. Orient Barrel Nuts with flats facing away from screws.

REV.	DATE	DCN #	DRAWING TREE #
v1	05 JAN 2009	E1000001	T0900305
-	-	-	-
-	-	-	-

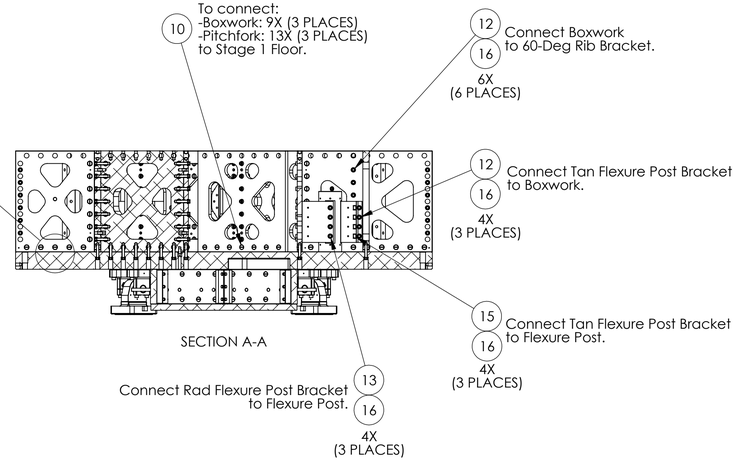




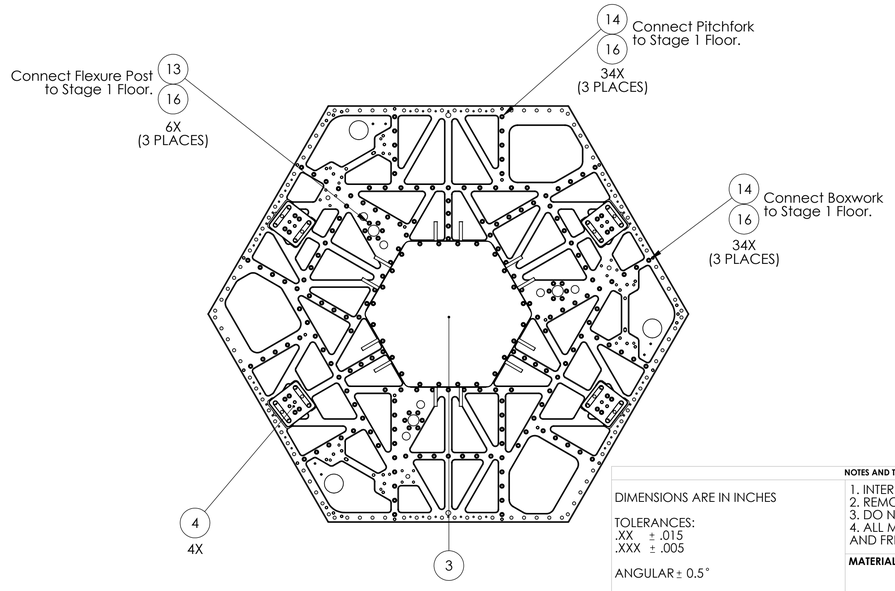




DETAIL B
SCALE 1 : 4



SECTION A-A



ITEM NO.	PART NUMBER	DESCRIPTION	SIZE / TYPE	MATERIAL	REQ
16	UCC_WFV-38	Vented Washer, 3/8"	3/8" (.39"x.63")	18-8 SS	388
15	MCMASTER_92196A635	SHCS, 3/8"-16x2.75"	3/8"-16x2.75"	18-8 SS	12
14	HOLOKROME_78106	SHCS, 3/8"-16x2.0"	3/8"-16x2.0"	18-8 SS	244
13	HOLOKROME_78104	SHCS, 3/8"-16x1.75"	3/8"-16x1.75"	18-8 SS	30
12	HOLOKROME_78100	SHCS, 3/8"-16x1.25"	3/8"-16x1.25"	18-8 SS	102
11	D071250	Barrel Nut	3/8-16 x 1.0L	2024-T351	162
10	D071250	Barrel Nut	3/8-16 x .75L	2024-T351	66
9	D071076	Flexure Post Bracket, Tan	-	6061-T6 Al	3
8	D071075	Flexure Post Bracket, Rad	-	6061-T6 Al	3
7	D071074	Flexure Post	-	6061-T6 Al	3
6	D071073	Rib Bracket, 60 Deg	-	6061-T6 Al	6
5	D071051	Stage 1 Floor	-	6061-T6 Al	1
4	D071450	Asm, Locker	-	See BOM	4
3	D071424	Asm, Keel	-	See BOM	1
2	D071423	Asm, Pitchfork	-	See BOM	3
1	D071422	Asm, Boxwork	-	See BOM	3

PARTS LIST

DIMENSIONS ARE IN INCHES

TOLERANCES:
.XX ± .015
.XXX ± .005

ANGULAR ± 0.5°

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

1. INTERPRET DRAWING PER ASME Y14.5-1994.
2. REMOVE ALL SHARP EDGES, R.02 MIN.
3. DO NOT SCALE FROM DRAWING.
4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.

MATERIAL See BOM

FINISH See BOM

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM ADVANCED LIGO

SUB-SYSTEM SEI

NEXT ASSY D0900124

PART NAME Stage 1 Pre-Asm, HAM ISI, Advanced LIGO

DESIGNER	Andy Stein	13 FEB 2009	
DRAFTER	Andy Stein	04 JAN 2010	
CHECKER			
APPROVAL	Ken Mason	05 JAN 2010	

SIZE D **DWG. NO.** D0900154 **REV.** v1

SCALE: 1:12 **PROJECTION:** SHEET 1 OF 1

D0900154_Stage_1_Pre-Asm-HAM_ISI-Advanced_LIGO_PART PDM REV- X-034, DRAWING PDM REV- X-007